

Work Order ID 68960

Tuesday, April 26, 2011 12:59:36 PM

Page 1

Item ID: D3564-5

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 4/26/2011 Start Qty: 20.00

Required Date: 4/29/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-26 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3564 | Rev D | | | | | | | | |

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ☒ Dwg Rev: D ☐ Prog Rev: D ☐ 2-

Deburr if necessary

304.063

R11-4-27

28

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

R11-4-27

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

8/10/28

counted
+22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68960

Tuesday, April 26, 2011 12:59:36 PM



Page 2

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/26/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary ☐ Form on Brake as per Dwg D3564 using Jigs DT8179 and DT8155 ☐ Form Joggle as per Dwg D3564 on brake using Jig DT8157

JB 11/04/28

22

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

8 11/04/28

count
+22

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

Memo

0.00

START TIME: 3:25 ☐ OVEN TEMPERATURE: 3:25
FINISH TIME: 3:25

11/5/28

22 BK 11-4-28

| W/O: | | WORK ORDER CHANGES | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 68960

Tuesday, April 26, 2011 12:59:36 PM



Page 3

Item ID: D3564-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 4/26/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

22 6 22 11-04-29

170

Identify as per dwg & Stock Location: *FD/9*

0.00



Packaging

Memo

0.00

Packaging

22 BR 11-4-28.

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/39

11-04-29
22

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 26, 2011 12:59:42 PM

Page 1

Work Order ID: 68960



Parent Item: D3564-5



Parent Item Name: Wearshoe



Start Date: 4/26/2011

Required Date: 4/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-03-08 ec
IPP Rev:B As per Rev C 07-07-09 JLM
IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC
IPP Rev D added DT# 08.04.21 DD Verified by EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued, | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---|----------------|--------|
| M304S16GA  | | Purchased | No | | | 100 | sf | 175.5000 | 1.5 | 31.57895 | 33. | | |
| | | | | | | | | | | |  | 175.5 | |
| | | | | | | | | | | | | 175.5 | |

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

175.5

117275

175.5

117275

23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 68960 |
| Description: Wearshoe | | Part Number: | D3564-5 |
| Inspection Dwg: D3564 Rev: D | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 43.50 | +/-0.030 | 43.50 | ✓ | | T B01 | |
| 6.75 | +/-0.030 | 6.75 | ✓ | | T | |
| 10.00 | +/-0.030 | 10.00 | ✓ | | T | |
| 20.00 | +/-0.030 | 20.00 | ✓ | | T | |
| 30.00 | +/-0.030 | 30.00 | ✓ | | T | |
| 2.50 | +/-0.030 | 2.50 | ✓ | | V B02 | |
| 3.227 | +/-0.010 | 3.225 | ✓ | | V | |
| 38.500 | +/-0.010 | 38.500 | ✓ | | T | |
| 5.500 | +/-0.010 | 5.500 | ✓ | | T | |
| 2.50 | +/-0.030 | 2.50 | ✓ | | V | |
| 2.432 | +/-0.010 | 2.436 | ✓ | | V | |
| 0.300 x 0.300 | +/-0.010 | 308x324 | ✓ | | V | |
| Ø0.188 | +0.005/-0.001 | .191 | ✓ | | V | |
| R0.375 | +/-0.010 | .375 | ✓ | | R.G. | |
| 0.063 | +/-0.010 | .059 | ✓ | | V | |
| | | | | | | |
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|-----------------------|-----------------------|----------------------------|-----|
| Measured by: B | Audited by: S | Prototype Approval: | N/A |
| Date: 11-4-27 | Date: 11/04/28 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.01.16 | New Issue | KJ/EC/DD | DD |

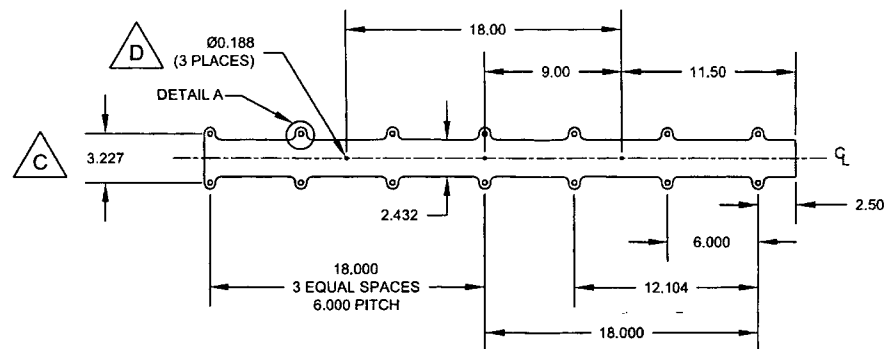
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

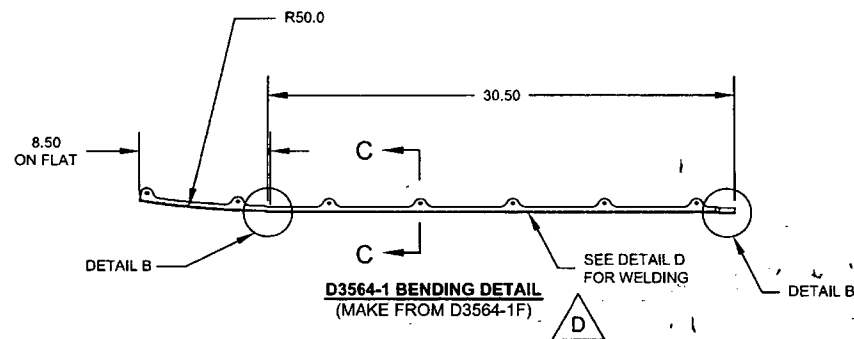
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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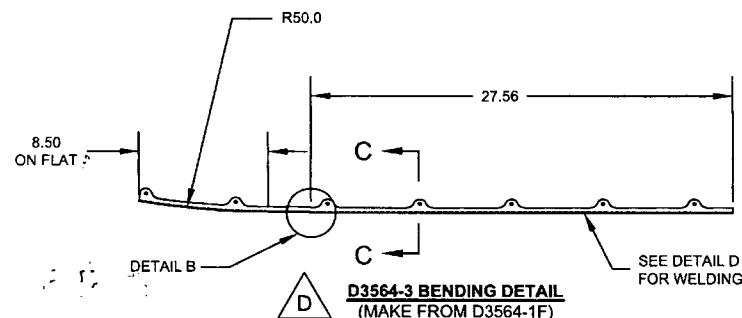
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT ϕ

WEIGHTS:

| | |
|----------|----------|
| D3564-1 | 1.85 lbs |
| D3564-3 | 1.85 lbs |
| D3564-5 | 1.93 lbs |
| D3564-7 | 1.26 lbs |
| D3564-9 | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68960
pl 11-04-26

RELEASED

07.09.04

| | | | |
|---|--|----|----------|
| D | UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB | 07.08.21 |
| C | MOVE TAB OUTBOARD, DETAIL A | PH | 07.04.17 |
| B | ADD AMS 5513 AND AMS 5524 | PH | 07.03.20 |
| A | NEW ISSUE | PH | 06.12.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | | |
| DRAWN | CB | | |
| CHECKED | PH | | |
| MFG. APPR. | PH | | |
| APPROVED | PH | | |
| DE APPR. | PH | | |
| DATE | 07.08.21 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE SCALE 1:8 REV. D SHEET 1 OF 3 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

| W/O: | | WORK ORDER CHANGES | | | | | | |
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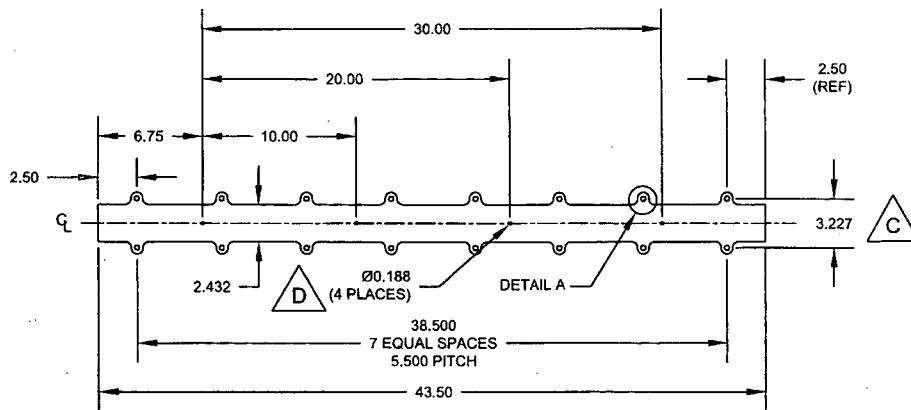
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

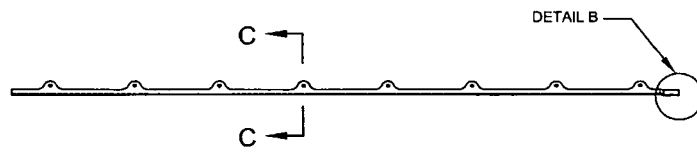
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NOTE: Date & initial all entries

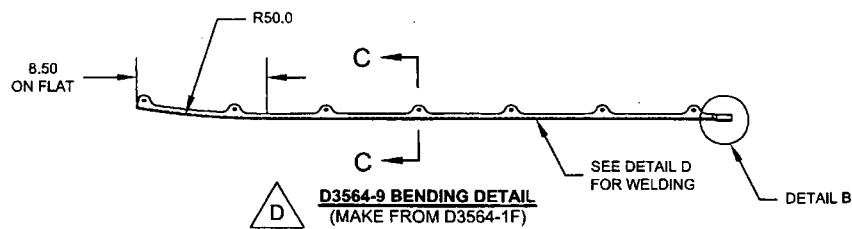
W/O 05960



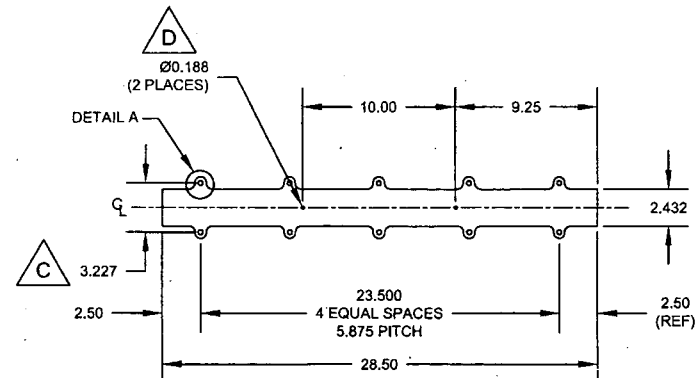
D3564-5F FLAT PATTERN



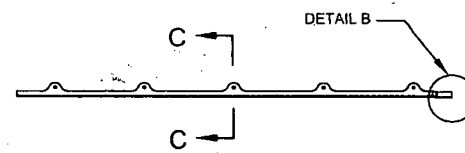
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



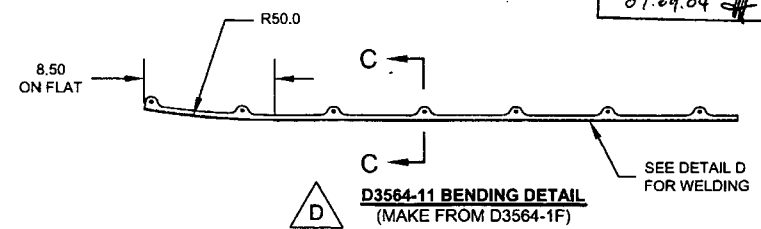
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED
07.09.04

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CB | | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 2 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1:8 |
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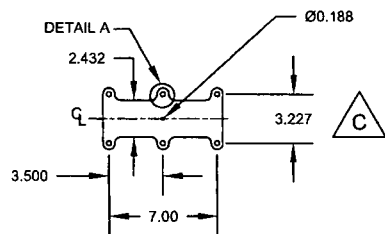
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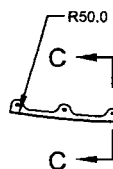
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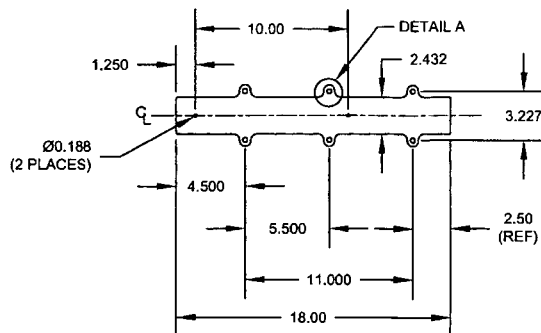
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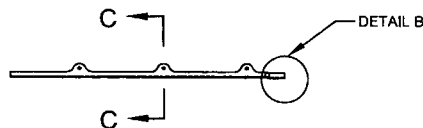
D3564-13F FLAT PATTERN



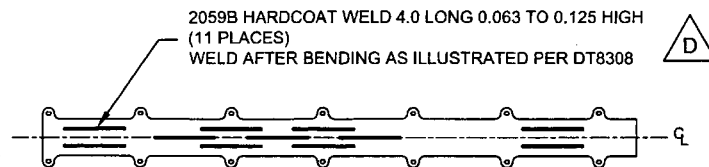
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



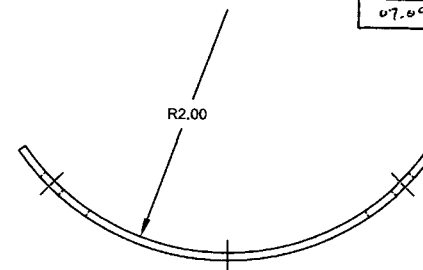
D3564-15F FLAT PATTERN



D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



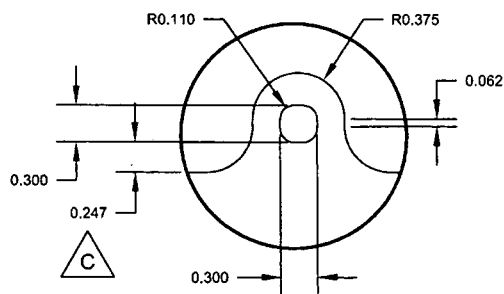
DETAIL D
(D3564-1/3/9/11 WELDING DETAIL)



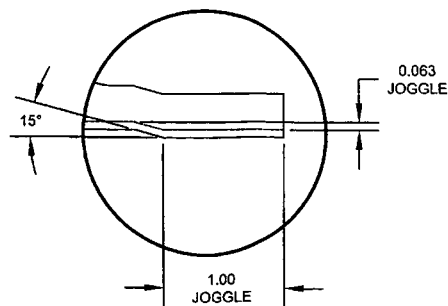
SECTION C-C
SCALE 1:1

RELEASED

07.09.04



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CS | | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 3 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1:8 |
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8 7 6 5 4 3 2 1

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